

Date: Thursday, 1/17/2008 3:24:03 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLANGE	
Job Number : 36816		
Estimate Number : 12314		
P.O. Number :	Part Number : D34739	OK FOR REV. B 06.01.18
This Issue : 1/17/2008 S.O. No. :	Drawing Number : D3473 REV B	
Prsht Rev. : NC	Project Number : N/A	
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B	
Previous Run : 34422	Material :	
Written By : <u>08.01.18</u>	Due Date : 2/10/2008	Qty: 10 Um: Each
Checked & Approved By : <u>08.01.18</u>		
Comment : Est Rev:A New Issue 06-03-02 JLM		
Est Rev:B As per Rev B 06-05-24 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S26GA	304/316 0.018 SHEET
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Comment: Qty.: 0.6305 sf(s)/Unit Total : 6.3053 sf(s)

304/316 0.018 SHEET

Batch: 165591 IB 8-1-23

2.0	WATER JET <u>165591</u>	FLOW WATER JET
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Comment: FLOW WATER JET

Cut as per Dwg D3473

Dwg Rev: B

Prog Rev: B

IB 8-1-23

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



IB 8-1-23

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

08/4/25 (10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

IB 8-1-23

2-Form as per Dwg D3473 using DT8860

MF 08-01-30

(10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 28/02/15

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:24:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGE

Job Number: 36816

Part Number: D34739

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/01/30

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

MF 08-02-01

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/02/04

Job Completion



Jim 2008/2/04

(10)

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

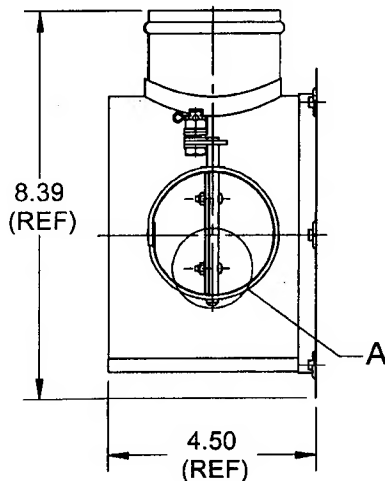
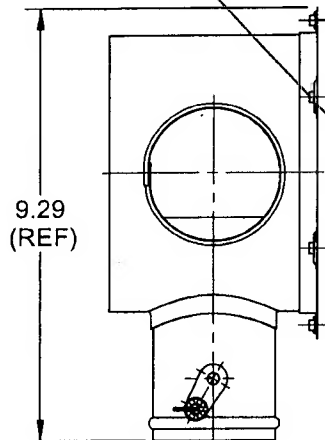
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3473	REV. B SHEET 1 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:4
A	06.02.07	NEW ISSUE	
B	06.05.16	D3473-5F/-7F: 9.750 & 8.810 WERE 9.60 & 8.60	

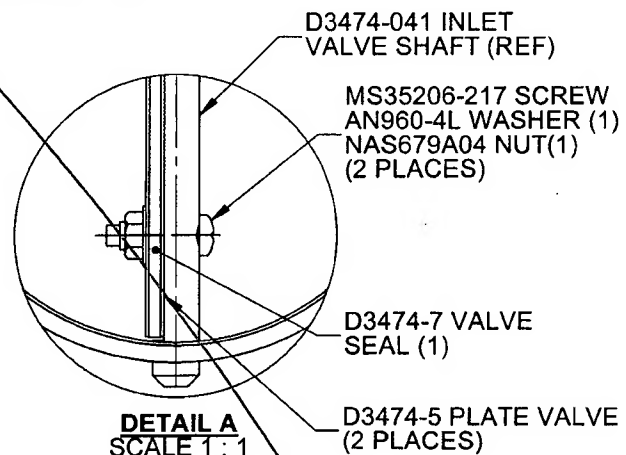
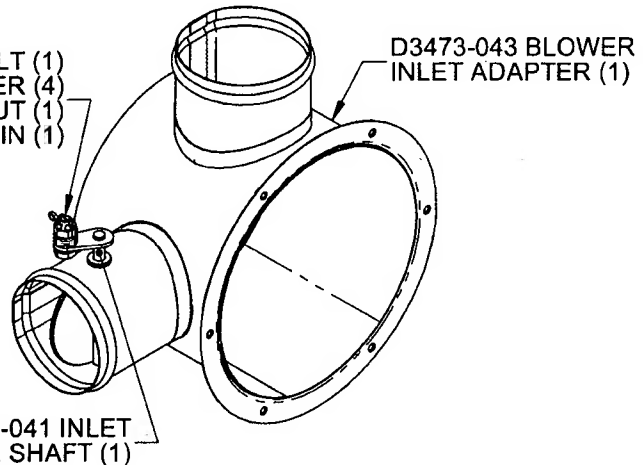
RELEASED
06-05-16



D3470-9 BOLT (1)
AN960-416 WASHER (4)
AN310-4 NUT (1)
MS24665-153 COTTER PIN (1)

UNDER REVIEW

02.04.03
Dirt & Manufacturing
Control



D3473-041 BLOWER INLET ADAPTER

NOTES:

- 1) IDENTIFY WITH DART P/N D3473-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3473-041	BLOWER INLET ADAPTER
1	D3470-9	BOLT
1	D3471-043	BLOWER INLET WELDMENT
1	D3474-041	INLET VALVE SHAFT SHOP COPY
2	D3474-5	BUTTERFLY VALVE RETURN TO
1	D3474-7	BUTTERFLY VALVE SEAL ENGINEERING
1	AN310-4	NUT
2	AN960-4L	WASHER
4	AN960-416	WASHER
1	MS24665-153	COTTER PIN
2	MS35206-217	SCREW
2	NAS679-A04	NUT

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WITHOUT NOTICE
WORK ORDER
NO. 36816

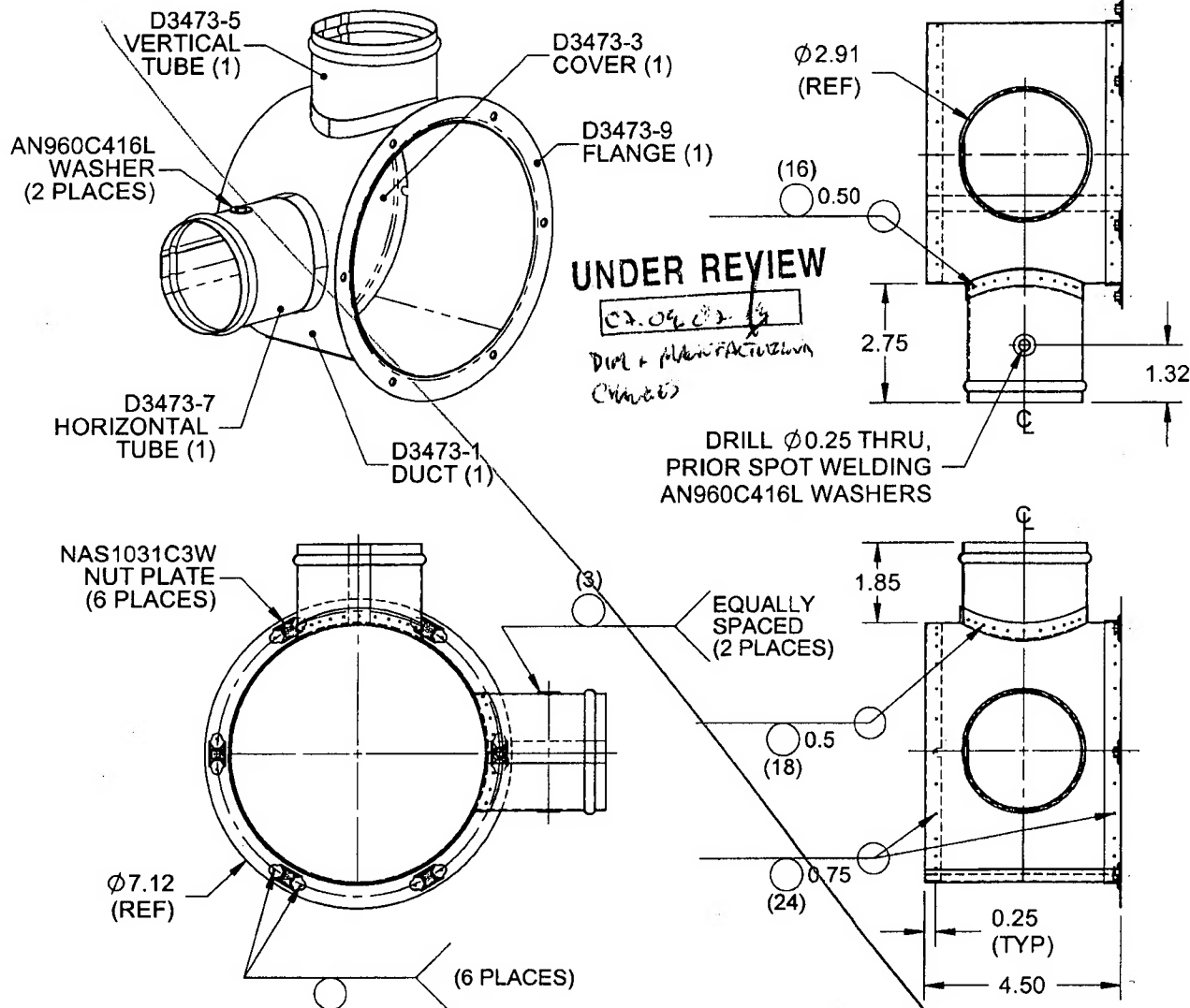
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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:4

RELEASED
06.05.16



D3473-043 BLOWER INLET WELDMENT

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3473-043	BLOWER INLET WELDMENT
1	D3473-1	DUCT
1	D3473-3	COVER
1	D3473-5	VERTICAL TUBE
1	D3473-7	HORIZONTAL TUBE
1	D3473-9	FLANGE
2	AN960C416L	WASHER
6	NAS1031C3W	NUT PLATE

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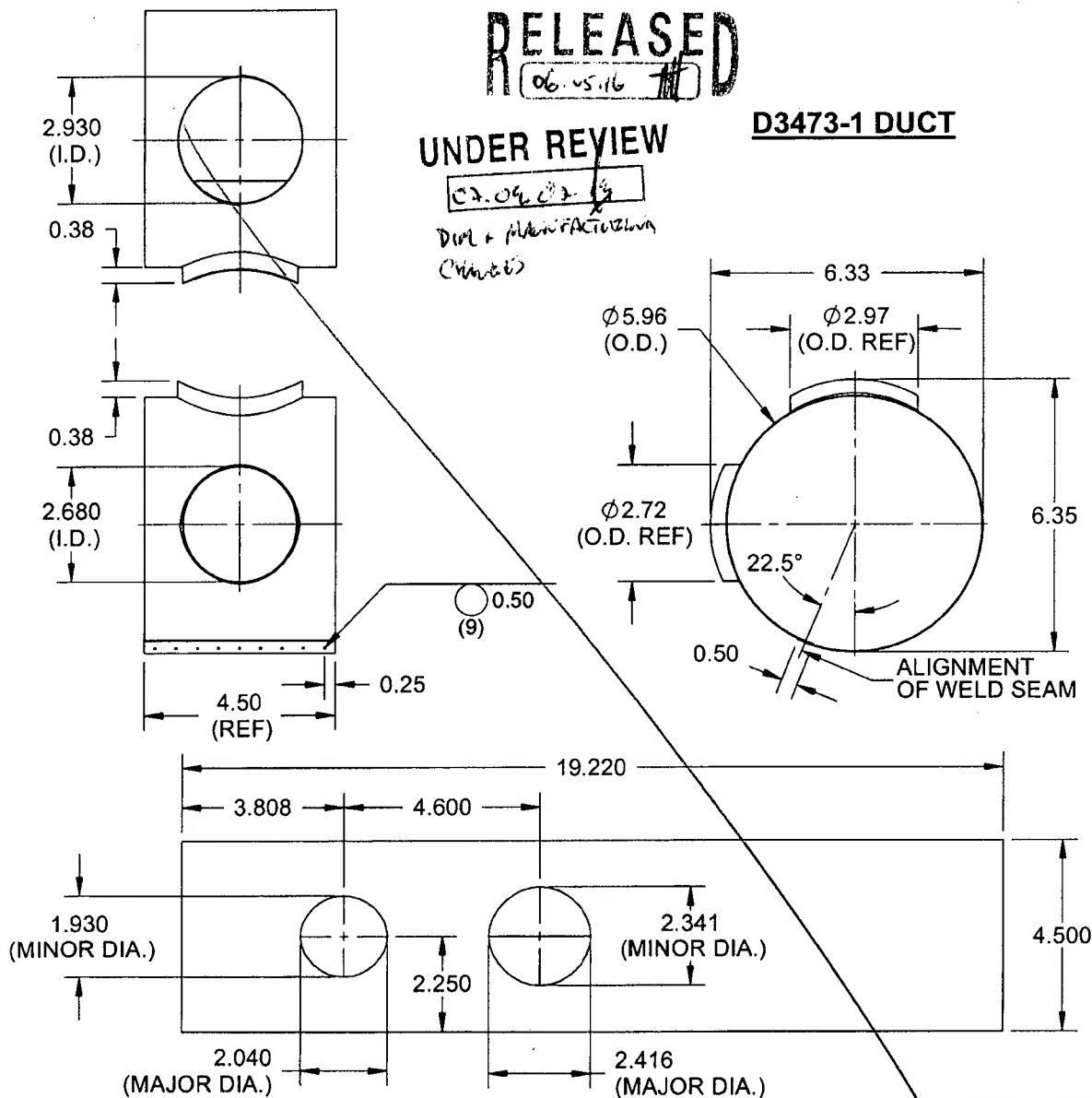


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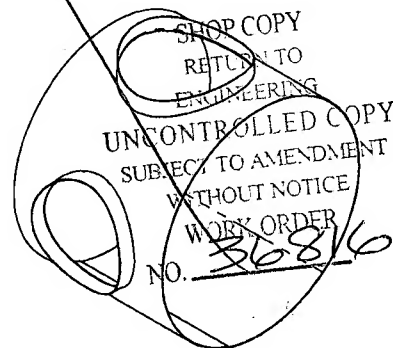
D3473-1 DUCT



D3473-1F DUCT FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)
2B FINISH 26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

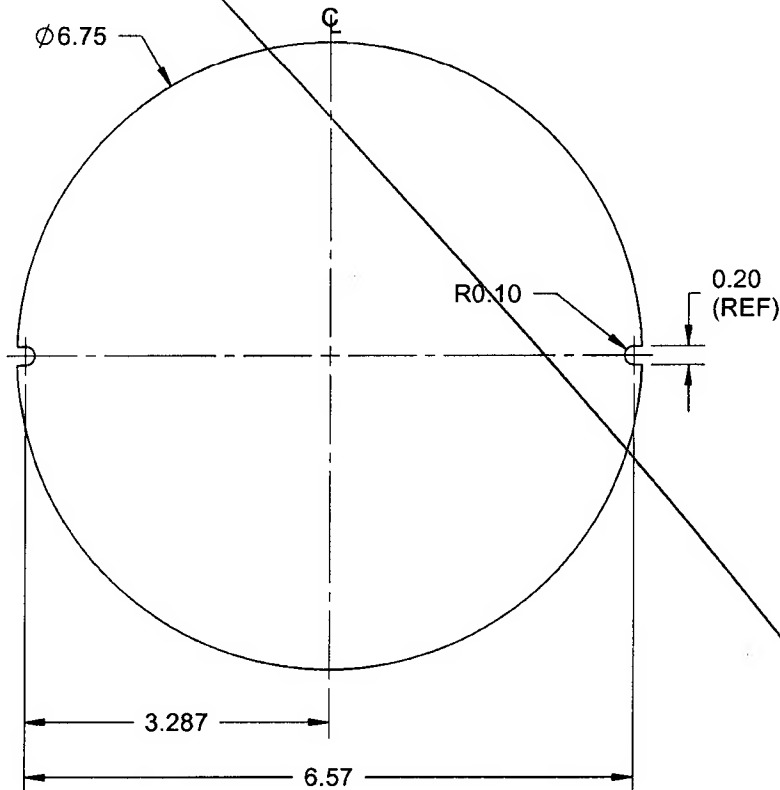
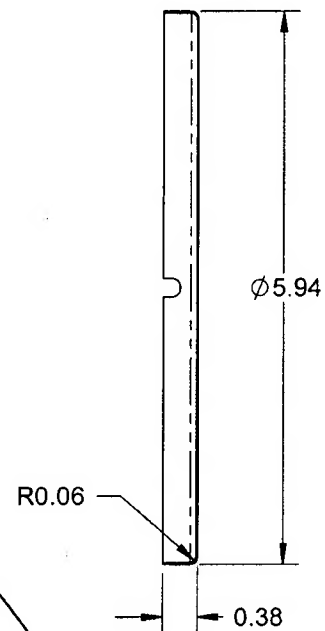


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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2

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06-05-16 *H***UNDER REVIEW**C2.09 C2.12
DIP + MANUFACTURING
CHECKS**D3473-3F COVER FLAT PATTERN****D3473-3 COVER****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

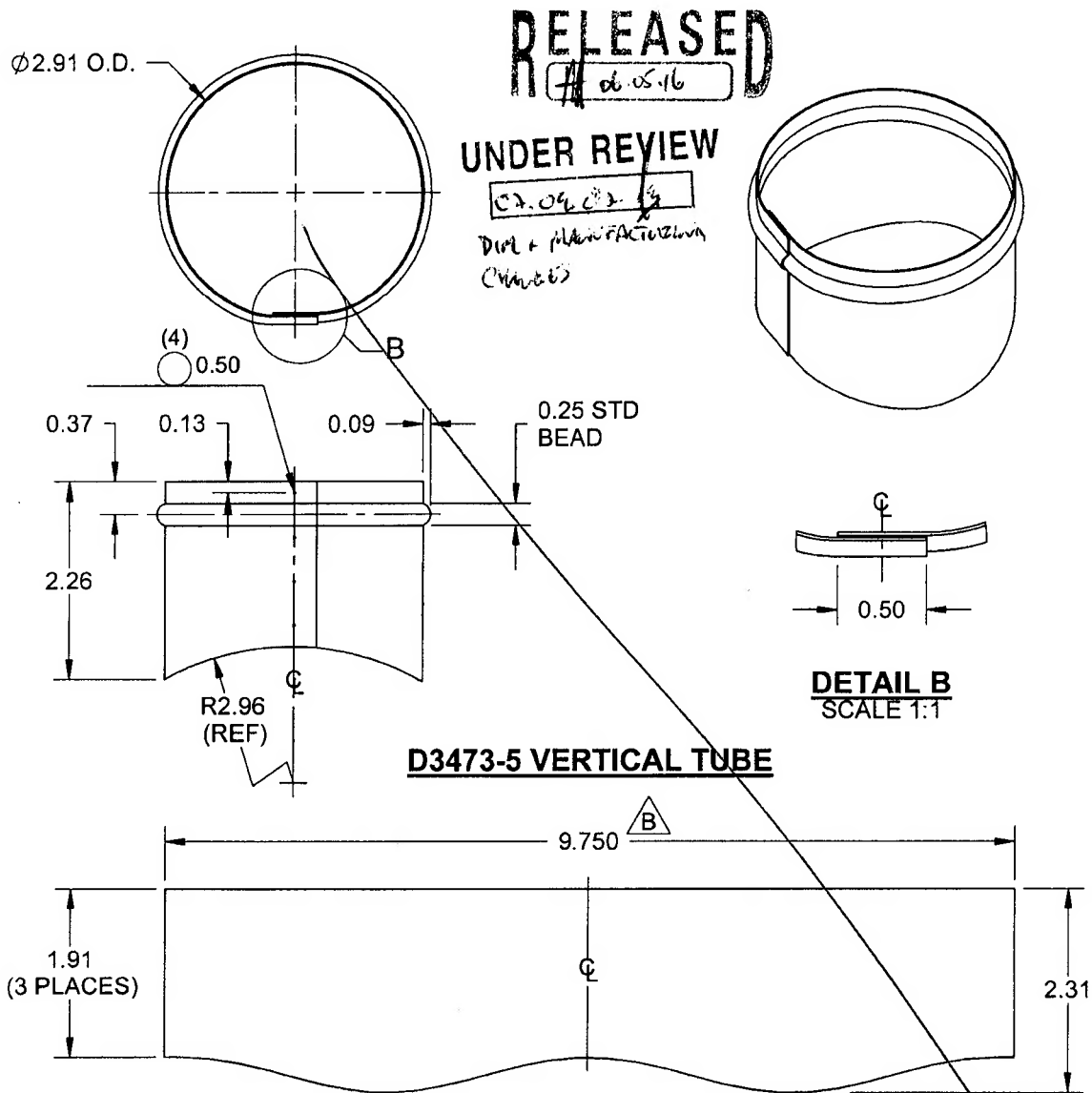
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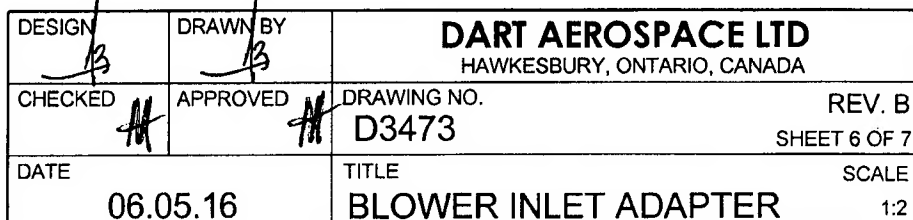
**D3473-5F VERTICAL TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B F
26 GAUGE SS (0.018 THICK)
2) SPOT WELD PER DART QSI 004
3) FINISH: NONE
4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES
7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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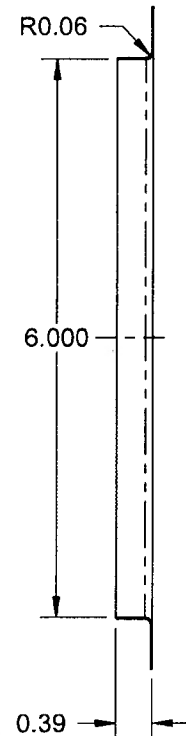
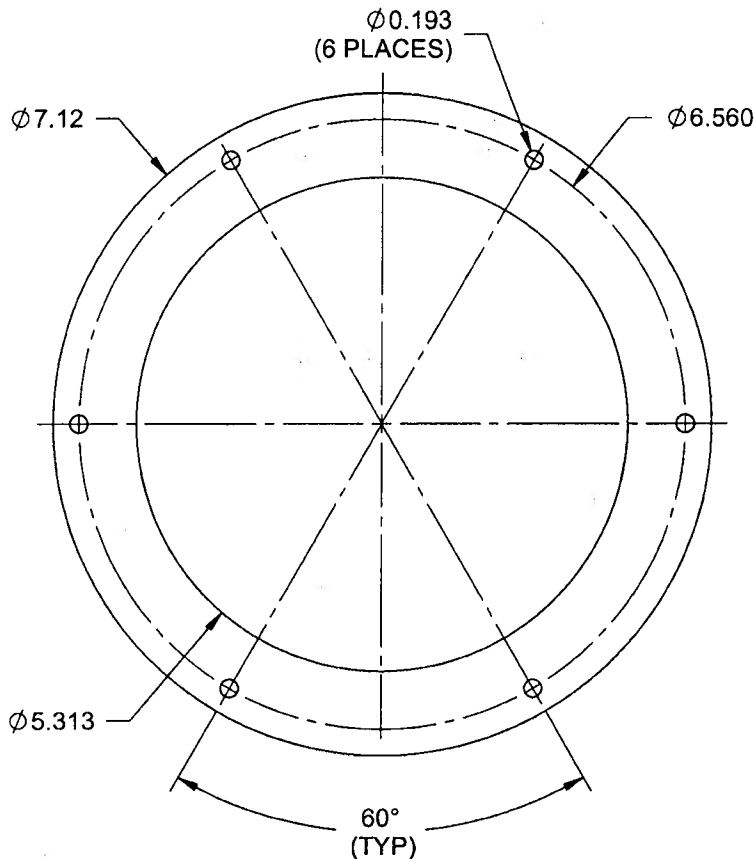
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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2

UNDER REVIEW

[Stamp: CH. 06.05.16]

Dim. & Plan. FACTORIAL
CH. 06.05.16

RELEASED
[Stamp: 06.05.16]



D3473-9F FLANGE FLAT PATTERN

D3473-9 FLANGE BENDING DETAIL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

OK per REV-B
06.05.16

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